

Date: Tuesday, 07/04/2009 10:19:57 AM
 User: Julie Dawson

Process Sheet

| | | | |
|------------------------------------|-------------------------------------------------|---------------------------|-------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | BRACKET |
| Job Number : | 46972 | | |
| Estimate Number : | 11139 | | |
| P.O. Number : | | Part Number : | D32051 |
| This Issue : | 07/04/2009 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D3205 REV A |
| First Issue : | // | Project Number : | N/A |
| Previous Run : | 43301 | Drawing Revision : | A |
| Written By : | | Material : | |
| Checked & Approved By : | JLD 09.04.07 | Due Date : | 24/04/2009 |
| Comment : | Est A 04.06.09 New issue KJ/RF | | |
| | Est Rev:B 08-12-16 attach DEO DD verified by:EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------------------|--------------------------|
| 1.0 | M7075T73B2500X0325 | 7075-T73 Bar 2.50 x 3.25 |
|-----|--------------------|--------------------------|



Comment: Qty.: 0.3828 f(s)/Unit Total : 1.9142 f(s)

7075-T73 Bar 2.5 x 3.25"

Material: 7075-T73 (QQ-A-200/11 or QQ-A-250/12) or 2024-T3 (QQ-A-200/3 or QQ-A-250/4)

(M7075T73B2.500x03.25)

Identify for D3205-1

Batch: ~~1102695~~ M102694

88 09/04/15

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW

Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)

88 09/04/15

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3205-1 as per Folio FA346 and Dwg D3205

Identify as D3205-1

Deburr and Tumble

88 09/04/17 J.F. 09/04/19 (5)

| | | |
|-----|-----|----------------------------------------|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|----------------------------------------|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/04/19 (5)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: D3205-1 PAR #: N/A Fault Category: Prod / Machinal NCR: (Yes) No DQA: D Date: 05/04/08
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 05/04/27

| NCR: <u>46972</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|--------------------------------------------------------------------------------------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 09.01.17 | 3.0 | 1 part scrap. Top bolt hole is cracked: off center, due to the part shifting during the center drill operation. Rec process | | Scrap: destroy no replace. replace part with same Batch: M102694 | 09/04/17 | 09/04/17 | | 09.01.17 |
| 09.01.17 | 2.0 | 1 blank was cut cracked on the faces, cannot be used for machining. Should be 4.250 is 4.1. R.C: Lead to lost on SAW | | Identify with the material #: place back in stock. Can maybe be used for another part or tooling. | BS 09/04/18 | 09/04/19 | | 09.01.17 |
| | | | | Scrap: replace part with same Batch: M102694 fixed saw problems By changing Blade. | BS 09/04/20 | 09.01.20 | | 09.01.20 |

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:19:58 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 46972

Part Number: D32051

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 09/04/20

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JL

09-04-21

(XS)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the thread hole for D3205-1 before powder coat.

M109648.

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:20
320°
11:50

BR 09-04-23

(5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-23

(XS)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 197

JL

09/04/24 (XS)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/24 JL

Job Completion



MUF
09-04-24

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 46972 |
| Description: Pedal Bracket | | Part Number: D3205-1 |
| Inspection Dwg: D3205 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.100 | +/-0.010 | 1.100 | ✓ | | | |
| 0.250 | +/-0.010 | 0.253 | ✓ | | | |
| R0.37 | +/-0.030 | 0.375 | ✓ | | | |
| 0.125 | +/-0.010 | 0.129 | ✓ | | | |
| 0.250 | +/-0.010 | 0.253 | ✓ | | | |
| 2.380 | +/-0.010 | 2.378 | ✓ | | | |
| 1.380 | +/-0.005 | 1.380 | ✓ | | | |
| 0.500 | +/-0.005 | 0.495 | ✓ | | | |
| 0.880 | +/-0.010 | 0.880 | ✓ | | | |
| Ø0.470 x 100° | +0.005/-0.000 | 0.470 x 100° | ✓ | | | |
| 0.440 | +/-0.005 | 0.442 | ✓ | | | |
| 0.600 | +/-0.005 | 0.599 | ✓ | | | |
| 1/4-28UNF-313 | N/A | 1/4-28UN | | | | |
| 0.250 | +/-0.010 | 0.246 | ✓ | | | |
| Ø0.257 | +0.005/-0.000 | 0.258 | ✓ | | | |
| 1.750 | +/-0.010 | 1.751 | ✓ | | | |
| 0.870 | +/-0.005 | 0.870 | ✓ | | | |
| 0.440 | +/-0.005 | 0.437 | ✓ | | | |
| R0.25 | +/-0.030 | 0.250 | ✓ | | | |
| 3.960" | ±0.030 | 3.964" | ✓ | | | |
| 3.562" | ±0.010 | 3.564" | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | |
|-------------------------|------------------------|--------------------------------|
| Measured by: DJP | Audited by: J.L | Prototype Approval: N/A |
| Date: 09/04/17 | Date: 09/04/20 | Date: N/A |

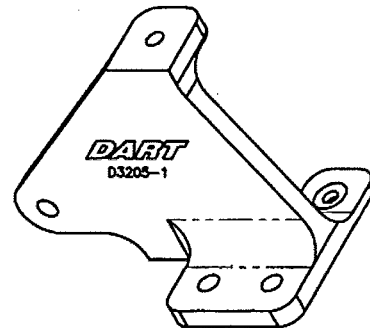
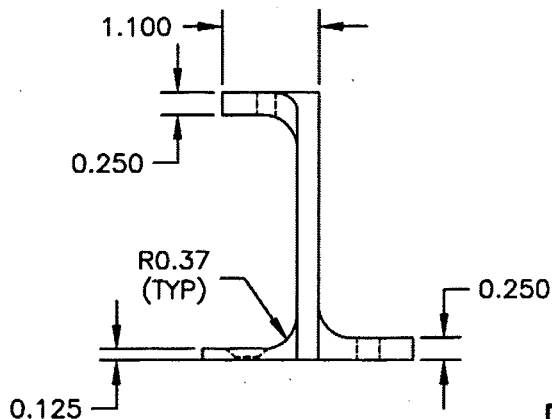
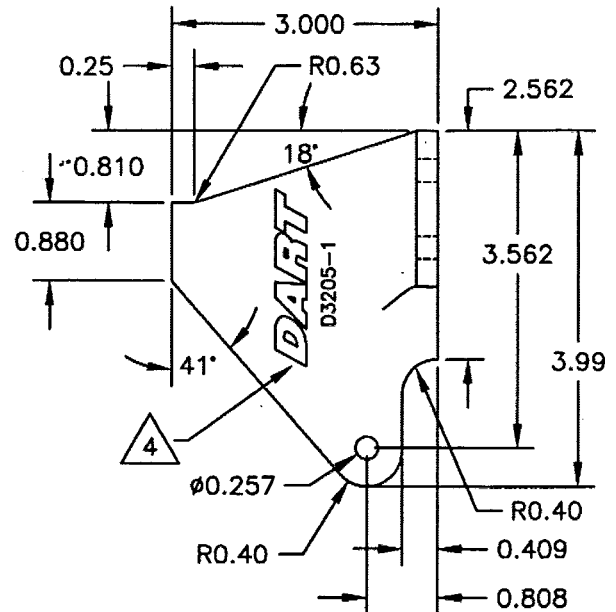
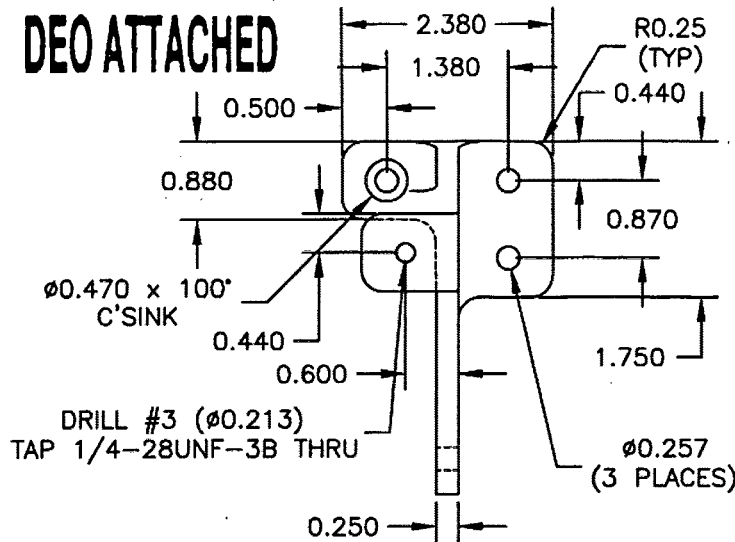
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 05.02.17 | New Issue | KJ/JLM | |

DART

| | | | |
|------------------|---------------|---------------------------------------------------|------------------------|
| DESIGN H | DRAWN BY H | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3205 | REV. A SHEET 1 OF 2 |
| DATE 04.01.27 | | TITLE BRACKET | SCALE 1:2 |
| A | 04.01.27 | NEW ISSUE | |

RELEASED
04.04.05

DEO ATTACHED



D3205-1 PEDAL BRACKET

NOTES:





- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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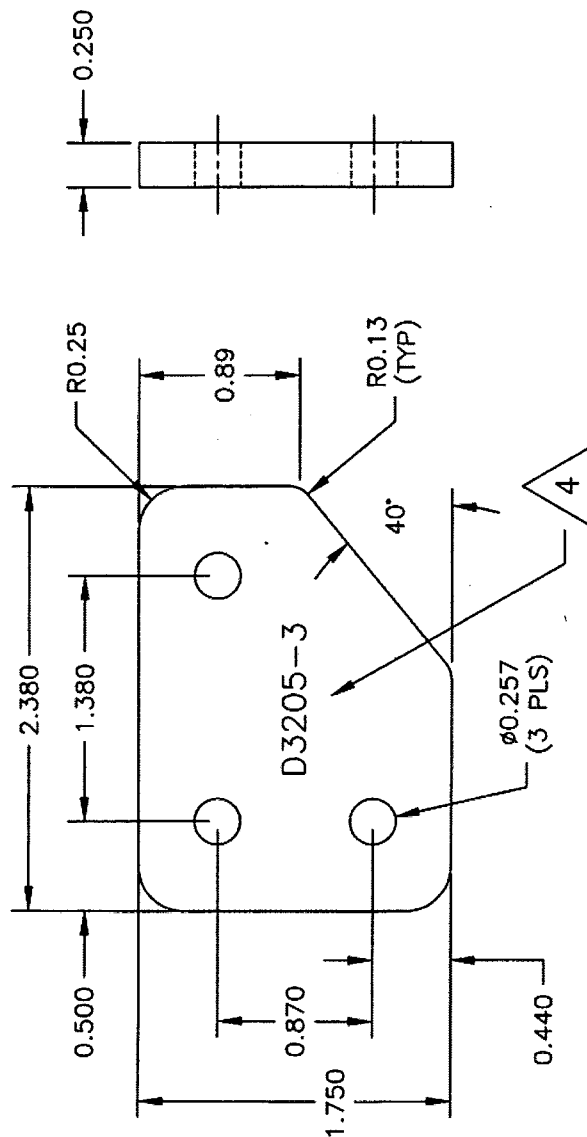
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| CHECKED  | APPROVED  | DRAWING NO. D3205 | REV. A SHEET 2 OF 2 |
| DATE 04.01.27 | | TITLE BRACKET | SCALE 1:1 |

RELEASED
04.04.05 #

DEO ATTACHED



D3205-3 BACK PLATE

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
3) ALUMINUM BAR (M6061T6B)
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
5) POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
6) ENGRAVE DART P/N AS SHOWN
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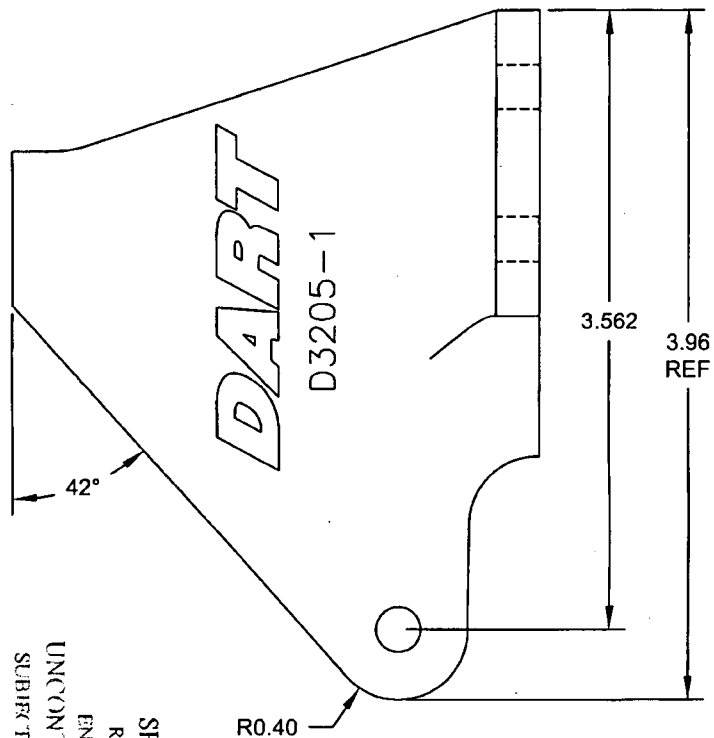
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| DRAWING NO. D3205 | TITLE BRACKET | REV. A | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3205-A-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN AJS | CHECKED <i>ls</i> | MFG. APPR. <i>[Signature]</i> | APPROVED <i>[Signature]</i> | | DE APPR. <i>[Signature]</i> | | |
| DATE 08.12.01 | DATE 08.12.01 | DATE 08/12/01 | DATE 08/12/01 | | DATE 08.12.01 | | |

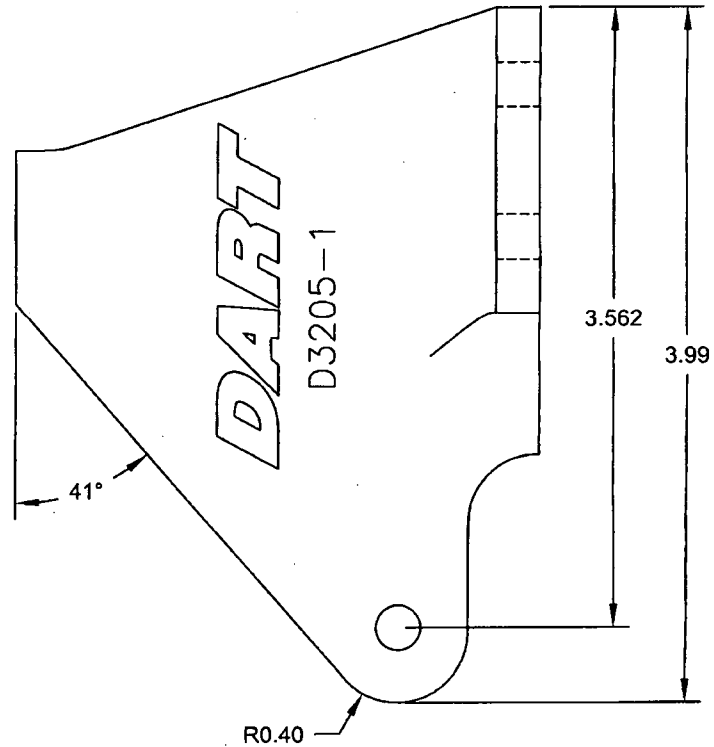
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